

Work Order ID 96005

January-17-13 1:19:27 PM

\*96005\*

Page 1

Item ID: D3805-041

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 1/17/13 Start Qty: 8.00

Required Date: 1/31/13 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *MLJ*

Date: *13-01-17* Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3805

B

100

0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805  
2059 B Hardcoat Welding Rod  
BATCH#: *M124170*

2-weld D3806-1 to D3805-1 together as per dwg D3805  
304 S.S. Welding Rod  
BATCH #: *M120854*

3-Transfer drill holes in bar

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

(3x) CC 13-02-07

3 13-02-07 DAS 09 2-09

20  
80

# Work Order ID 96005

January-17-13 1:19:27 PM

\*96005\*

Page 2

Item ID: D3805-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 1/17/13 Start Qty: 8.00 \*8\*

Cust Item ID:

Required Date: 1/31/13 Req'd Qty: 8.00 \*8\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

3

13-02-07



130

Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3

0.00

\*130\*

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:30

OVEN TEMPERATURE: 320

FINISH TIME: 8:00

3

13-02-11

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

13-02-11

3





Work Order ID 96005

January 17-13 1:19:27 PM

\*96005\*

Page 3

Item ID: D3805-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 1/17/13 Start Qty: 8.00

\*8\* 3  
\*8\*

Cust Item ID:

Required Date: 1/31/13 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

0.00

\*150\*

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m  
1300/1300L scotch grip adhesive as per dwg  
BATCH: 1124297

3 13.03.13  
A1

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

3m  
13313

3

170

Identify as per dwg & Stock Location: EP004

0.00

\*170\*

Packaging

Memo

0.00

Packaging

43 13/03/14



# Work Order ID 96005

\*96005\*

Page 4

January-17-13 1:19:27 PM

Item ID: D3805-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 1/17/13 Start Qty: 8.00

\*8\*  
\*8\*

Cust Item ID:

Required Date: 1/31/13 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

13/3/14

RB-03-14





# Picklist Print

January-17-13 1:19:31 PM

Page 1

Work Order ID: 96005

\*96005\*

Parent Item: D3805-041

\*D3805-041\*

Parent Item Name: Wearplate Assembly Fwd, Low Gear

Start Date: 1/17/13

Required Date: 1/31/13

Start Qty: ~~8.00~~ 3

Required Qty: ~~8.00~~ 3

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

|           |  |              |    |  |  |     |      |         |    |    |  |             |  |
|-----------|--|--------------|----|--|--|-----|------|---------|----|----|--|-------------|--|
| D3805-1   |  | Manufactured | No |  |  | 100 | Each | 30.0000 | 1  | 83 |  |             |  |
| *D3805-1* |  |              |    |  |  |     |      |         | ** |    |  | CC 13-02-07 |  |
| Plate     |  |              |    |  |  |     |      |         |    |    |  |             |  |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA001    | 30      |          |
| 75674    | 1       |          |
| 79621    | 10      |          |
| 93665    | 19      |          |

|           |  |              |    |  |  |     |      |         |    |    |  |             |  |
|-----------|--|--------------|----|--|--|-----|------|---------|----|----|--|-------------|--|
| D3806-1   |  | Manufactured | No |  |  | 100 | Each | 26.0000 | 1  | 83 |  |             |  |
| *D3806-1* |  |              |    |  |  |     |      |         | ** |    |  | CC 13-02-07 |  |
| Bar       |  |              |    |  |  |     |      |         |    |    |  |             |  |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA001    | 26      |          |
| 74888    | 4       |          |
| 91201    | 6       |          |
| 91202    | 10      |          |
| 93681    | 6       |          |

846009 → 48 x3

Picklist Print

January-17-13 1:19:31 PM

Work Order ID: 96005

\*96005\*

Parent Item: D3805-041

\*D3805-041\*

Parent Item Name: Wearplate Assembly Fwd. Low Gear

Start Date: 1/17/13

Required Date: 1/31/13

Start Qty: 8.00

Required Qty: 8.00

D3807-1

Manufactured No

150

Each

84.0000

1

8

\*D3807-1\*

\*\*

Ac 13.03.02

Gasket

Location

Loc Qty

Loc Code

GA

84

69022

2

74943

1

76741

2

79625

5

90477

3

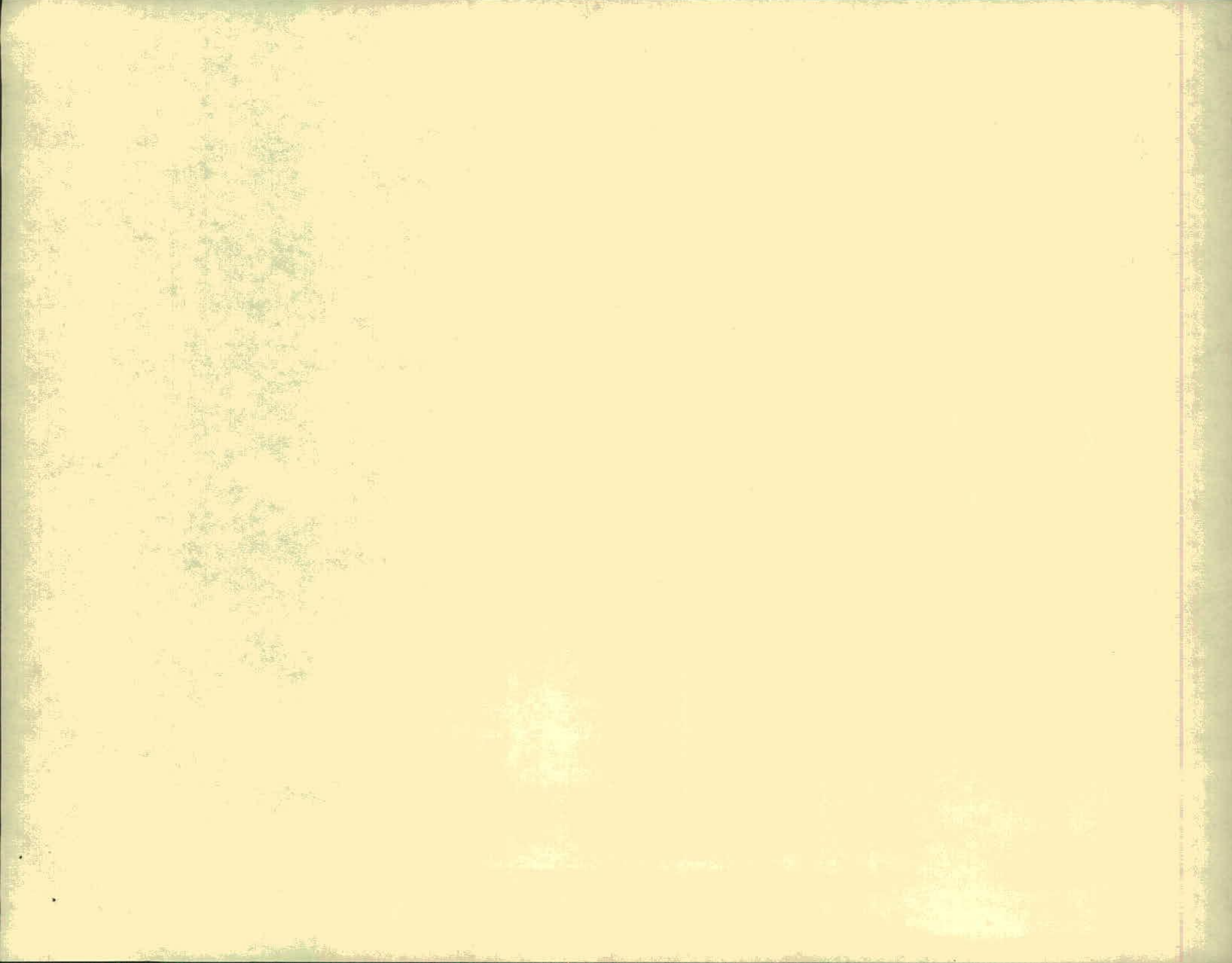
91203

29

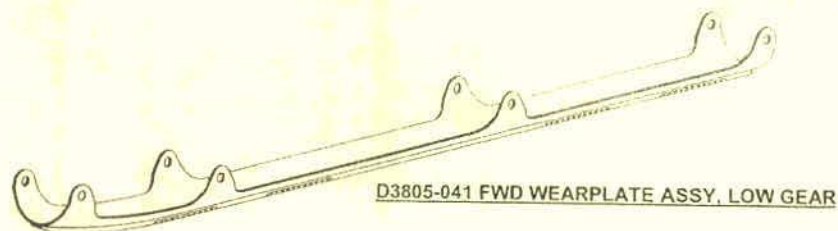
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42

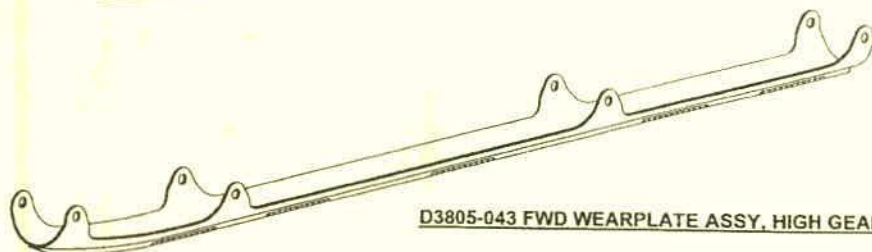
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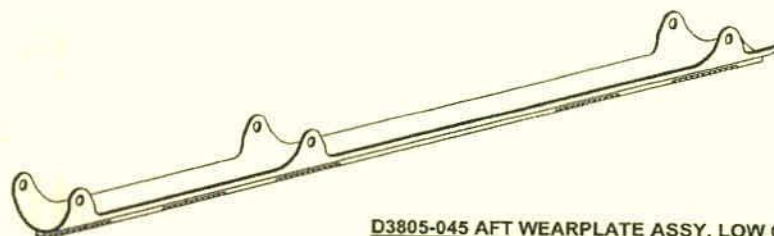




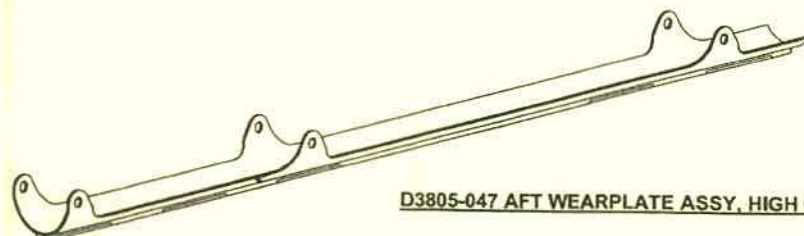
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

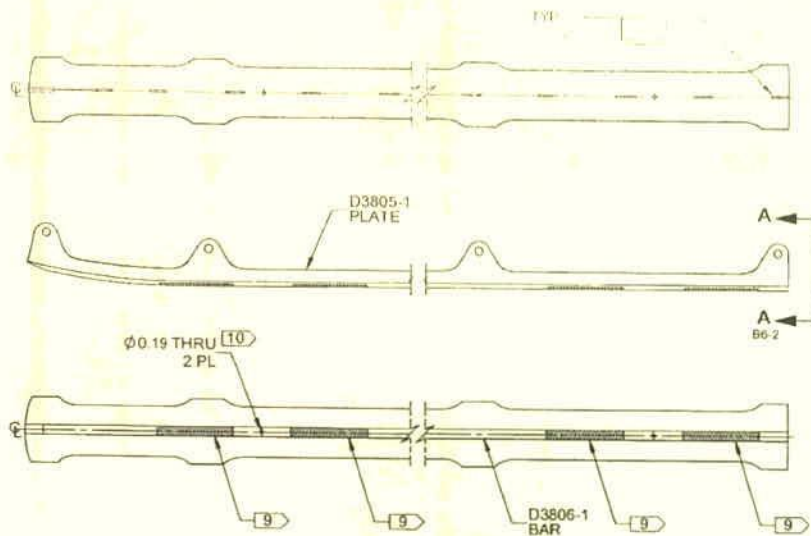
| ITEM | QTY | QTY | QTY | QTY | PIN             | DESCRIPTION                             |
|------|-----|-----|-----|-----|-----------------|---|
| 1    | 2   |     |     |     |                 | D3805-041 FWD WEARPLATE ASSY, LOW GEAR  |
| 2    |     | X   |     |     |                 | D3805-043 FWD WEARPLATE ASSY, HIGH GEAR |
| 3    |     |     | X   |     |                 | D3805-045 AFT WEARPLATE ASSY, LOW GEAR  |
| 4    |     |     |     | X   |                 | D3805-047 AFT WEARPLATE ASSY, HIGH GEAR |
| 11   | 1   |     |     |     |                 | D3805-1 PLATE                           |
| 12   |     | 1   |     |     |                 | D3805-3 PLATE                           |
| 13   |     |     | 1   |     |                 | D3805-5 PLATE                           |
| 14   |     |     |     | 1   |                 | D3805-7 PLATE                           |
| 15   | 1   |     |     |     |                 | D3806-1 BAR                             |
| 16   |     | 1   |     |     |                 | D3806-3 BAR                             |
| 17   |     |     | 1   |     |                 | D3806-5 BAR                             |
| 18   |     |     |     | 1   |                 | D3806-7 BAR                             |
| 19   | 1   |     |     |     |                 | D3807-1 GASKET                          |
| 20   |     | 1   |     |     |                 | D3807-3 GASKET                          |
| 21   |     |     | 1   |     |                 | D3807-5 GASKET                          |
| 22   |     |     |     | 1   |                 | D3807-7 GASKET                          |
| 31   | A/R | A/R | A/R | A/R | 2059B           | HARDCOAT                                |
| 32   | A/R | A/R | A/R | A/R | 1300 (OR 1300L) | 3M SCOTCH-GRIP ADHESIVE                 |

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2011-10-03  
MD

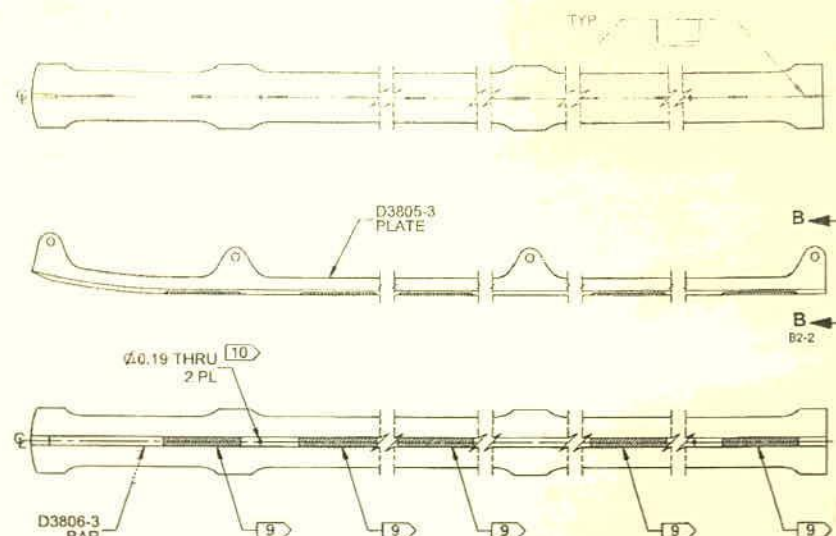
96005 M.C.S  
13-01-17

|            |  |  |    |          |
|------------|--|--|----|----------|
| B          | REVISED D3805-1F-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3 |  | MB | 11.09.16 |
| A          | NEW ISSUE  |  | MB | 08.11.21 |
| REV.       | DESCRIPTION  |  | BY | DATE     |
| DESIGN     | <i>gt</i>  | <b>DART AEROSPACE USA, INC.</b><br>KENT, WA<br>DRAWING NO. <b>D3805</b><br>TITLE <b>WEARPLATE ASSY</b><br>REV. B<br>SHEET 1 OF 8<br>SCALE<br>NTS<br>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.<br><small>THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. USE IS LIMITED TO THE SPECIFIC CONTRACT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |    |          |
| DRAWN      | <i>gt</i>  |  |    |          |
| CHECKED    | <i>gt</i>  |  |    |          |
| MFG. APPR. | <i>gt</i>  |  |    |          |
| APPROVED   | <i>gt</i>  |  |    |          |
| DE APPR.   | <i>gt</i>  |  |    |          |
| DATE       | 11.09.16   |  |    |          |





**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



**VIEW A-A C5-2**



**VIEW B-B C1-2**

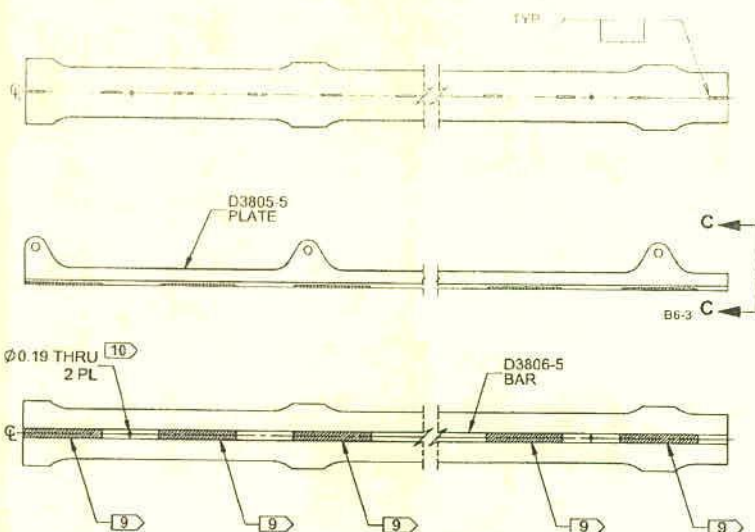
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

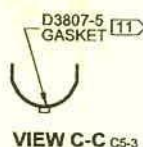
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2011-10-03

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| DRAWN      |          | KENT, WA  |              |
| CHECKED    |          | DRAWING NO.   | REV. B       |
| MFG. APPR. |          | D3805   | SHEET 2 OF 8 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | WEARPLATE ASSY  | NTS          |
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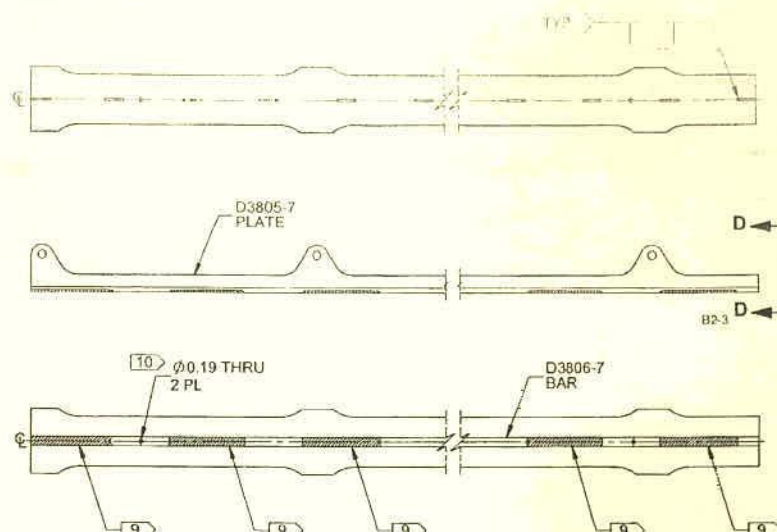




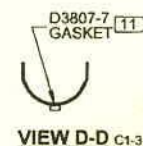
**D3805-045 AFT WEARPLATE ASSY.**



**VIEW C-C C5-3**



**D3805-047 AFT WEARPLATE ASSY.**



**VIEW D-D C1-3**

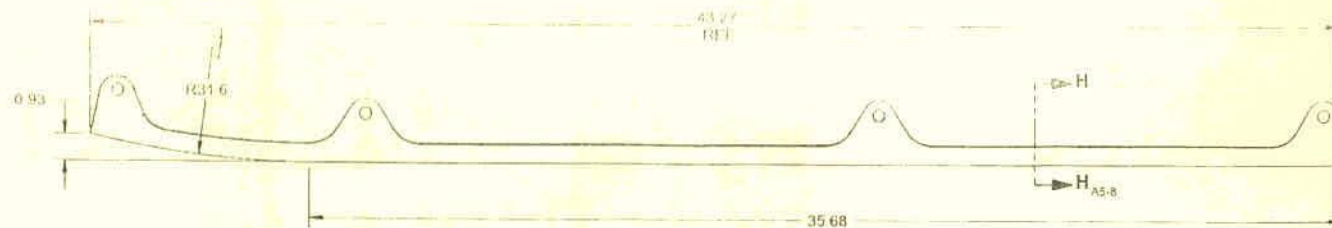
**RELEASED**  
2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4,3,5,6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
  - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

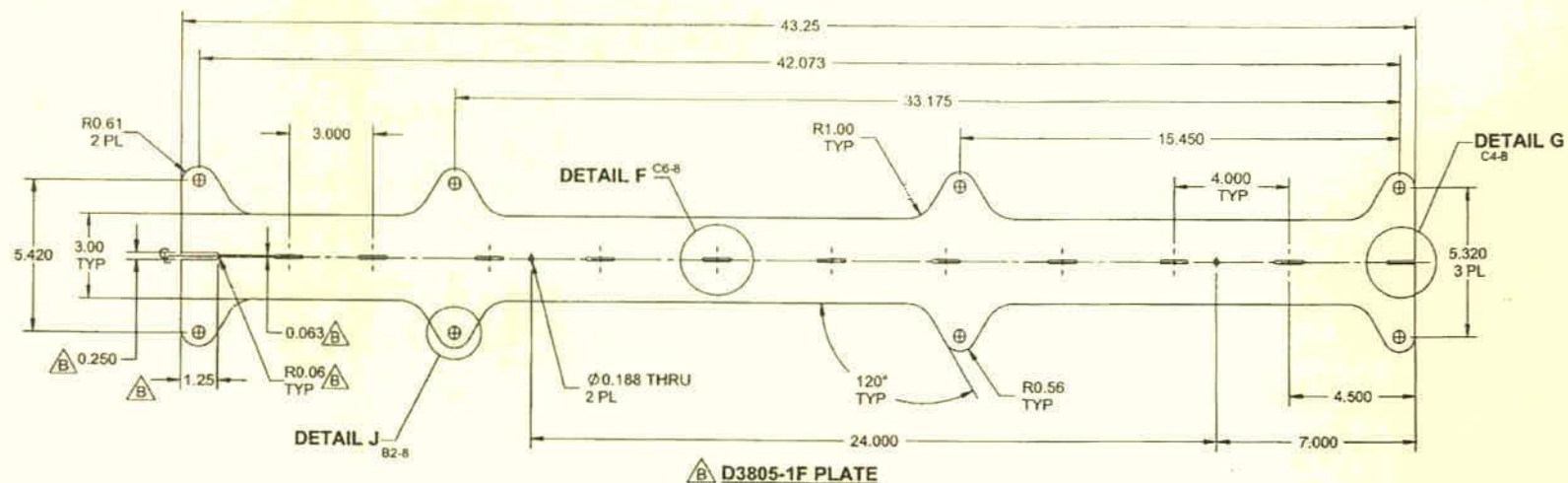
|            |          |   |              |
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| DESIGN     |          | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      |          | KENT, WA  |              |
| CHECKED    |          | DRAWING NO.   | REV. B       |
| MFG. APPR. |          | D3805   | SHEET 3 OF 8 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | WEARPLATE ASSY  | NTS          |
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**D3805-1 PLATE**  
(MAKE FROM D3805-1F)



**D3805-1F PLATE**

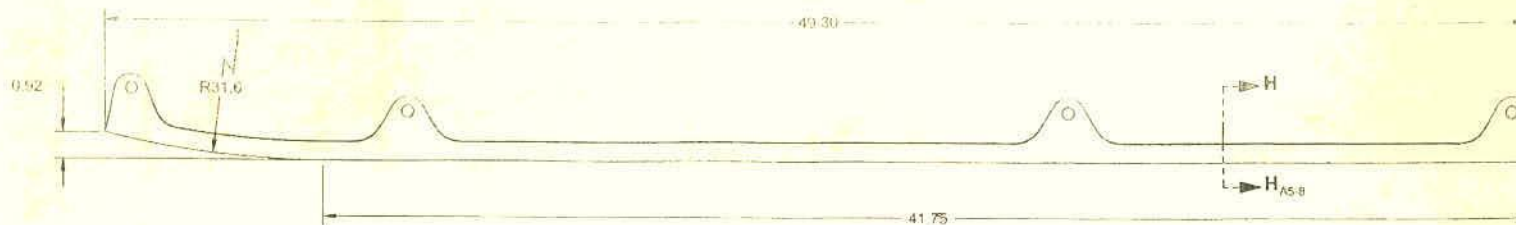
**RELEASED**  
2011-10-03  
JW

**NOTES:**

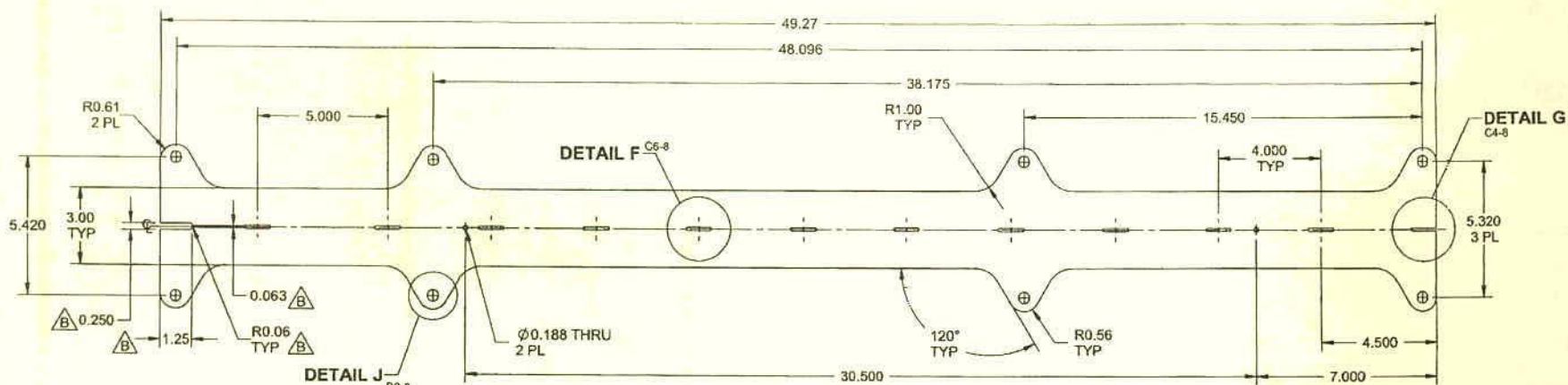
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | 97       | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      | JP       | KENT, WA  |              |
| CHECKED    | JP       | DRAWING NO.   | REV. B       |
| MFG. APPR. | JP       | D3805   | SHEET 4 OF 8 |
| APPROVED   | JP       | TITLE   | SCALE        |
| DE APPR.   | JP       | WEARPLATE ASSY  | NTS          |
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**D3805-3 PLATE**  
(MAKE FROM D3805-3F)



**D3805-3F PLATE**

**RELEASED**  
2011-10-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.36 lbs

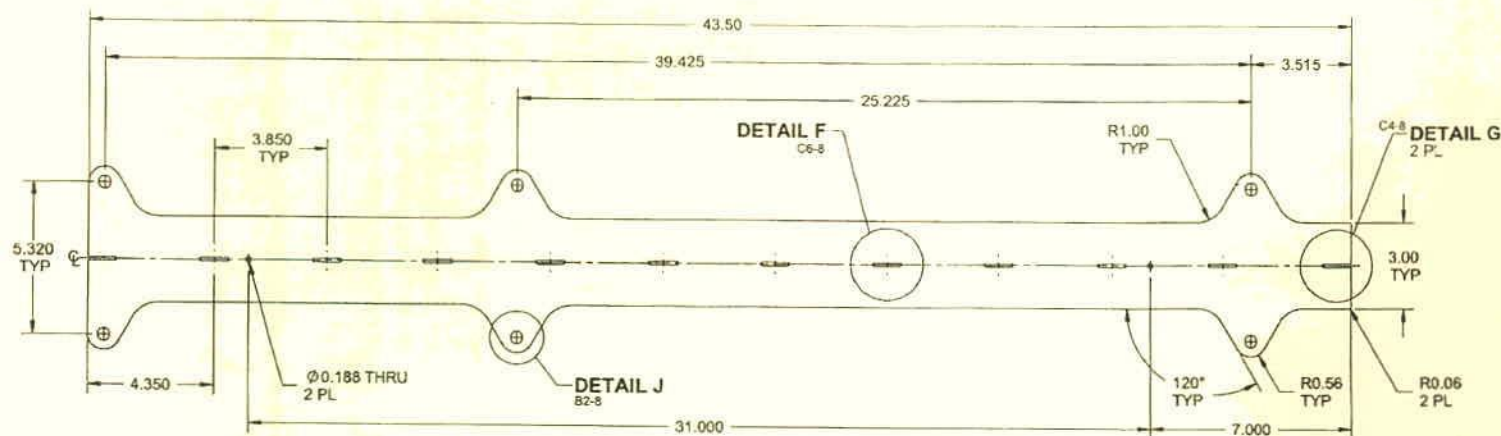
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|------------|----------|---|--------------|
| DESIGN     |          | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      |          | KENT, WA  |              |
| CHECKED    |          | DRAWING NO.   | REV. B       |
| MFG. APPR. |          | <b>D3805</b>  | SHEET 5 OF 8 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | <b>WEARPLATE ASSY</b>   | NTS          |
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**D3805-5 PLATE**  
(MAKE FROM D3805-SF)



**D3805-5F PLATE**

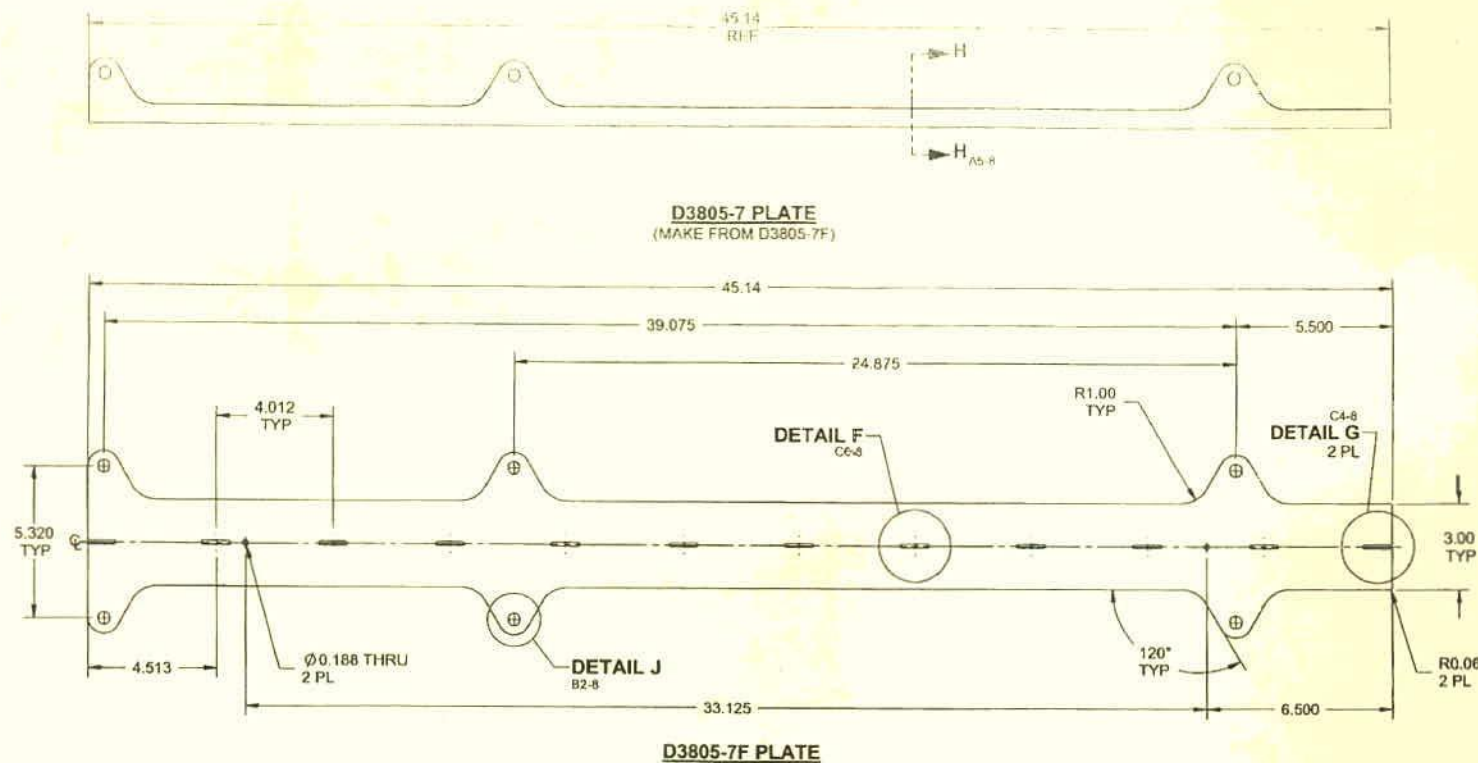
**RELEASED**  
2011-10-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE USA, INC.</b>  |              |
| DRAWN      |          | KENT, WA   |              |
| CHECKED    |          | DRAWING NO.  | REV. B       |
| MFG. APPR. |          | D3805  | SHEET 8 OF 8 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | WEARPLATE ASSY   | NTS          |
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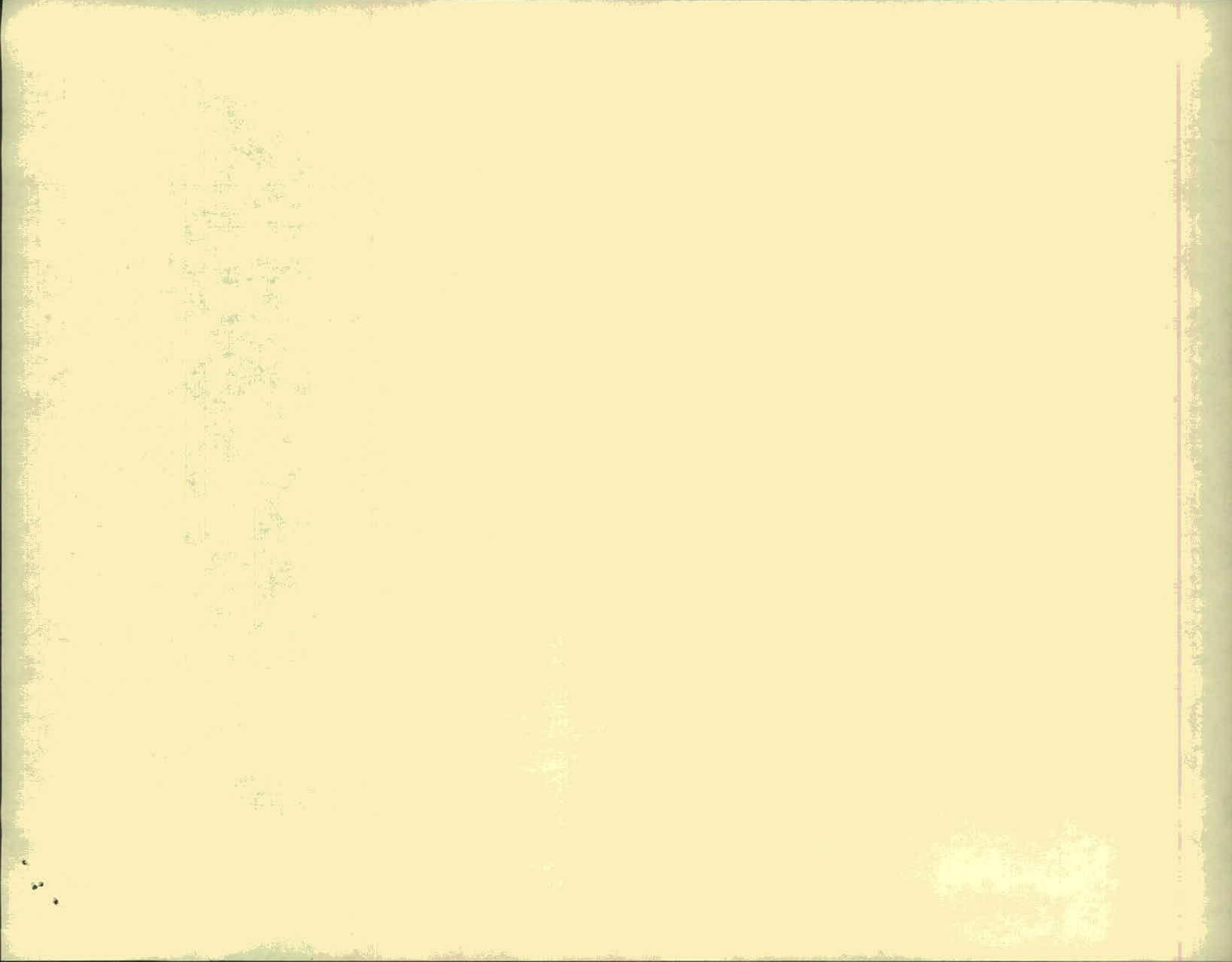


**RELEASED**  
2011-10-03

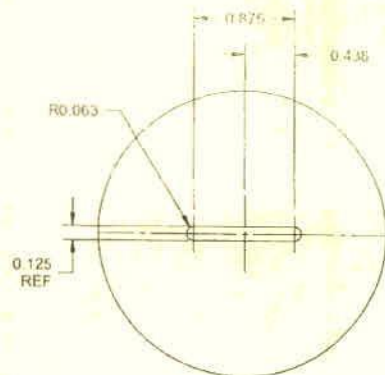
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

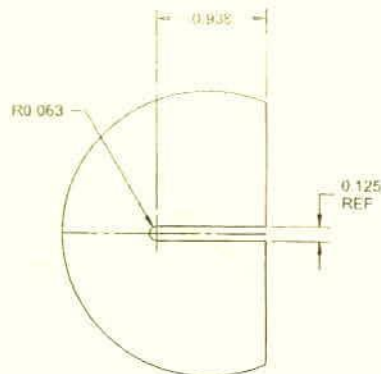
|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE USA, INC.</b>  |              |
| DRAWN      |          | KENT, WA   |              |
| CHECKED    |          | DRAWING NO.  | REV. B       |
| MFG. APPR. |          | D3805  | SHEET 7 OF 8 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | WEARPLATE ASSY   | NTS          |
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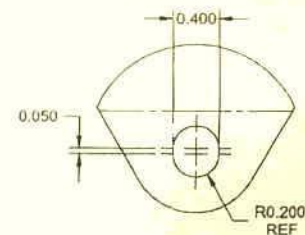




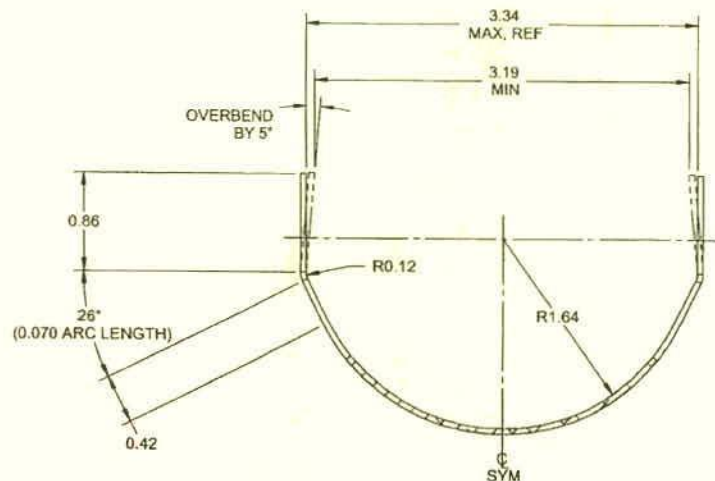
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X  
C5-4  
C5-5  
C4-6  
C4-7



**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X  
C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X  
B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X  
D3-4  
D3-5  
D3-6  
D3-7

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2011-10-03

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | 97       | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      |          | KENT, WA  |              |
| CHECKED    |          | DRAWING NO. D3805   | REV. B       |
| MFG. APPR. |          |   | SHEET 8 OF 8 |
| APPROVED   |          | TITLE WEARPLATE ASSY  | SCALE NTS    |
| DE APPR.   |          |   |              |
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